

Work Order ID 65839



Page 1

Wednesday, January 26, 2011 11:33:30 AM

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 1/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *HL*

Date: 1/01/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100



DC

Document Control

DOCUMENT CONTROL

0.00

SB 11/04/13

Memo

0.00

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

for BG 11-4-13
nl n 04 14 ①

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: *4109929*
COAT exposed HARDWARE WITH LPS PROCYON.
A/R LPS PROCYON BATCH: *M114596*

ES 4/04/13 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 11 04 13 ①

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/14/13

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

ml 11 04 14 ①

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Picklist Print

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Work Order ID: 65839

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding



Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 Nut		Purchased	No			110	Each	23.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		23							
					111819	23				2			
AN3C21A BOLT		Purchased	No			110	Each	48.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		48							
					109148	48				2			
AN8C16 Bolt		Purchased	No			110	Each	67.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST345		67							
					105969	7				2			
					106066	60							
D2012-107 Clevis		Manufactured	No			110	Each	16.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST004		16							
					62242	16				1			

SB 11/04/13

SB 11/04/13

SB 11/04/13

11/4/13 SP

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2803-042 Manufactured No

110 Each

9.0000

1

1



Bracket Assembly



SB 11/04/13

Location

Loc Qty

Loc Code

ST149

9

61725

3

64093

6

D2804-042 Manufactured No

110 Each

4.0000

1

1



Bracket Assembly



SB 11/04/13

Location

Loc Qty

Loc Code

ST150

4

62077

4

D2807-041 Manufactured No

110 Each

29.0000

2

2



Door prop



SB 11/04/13

Location

Loc Qty

Loc Code

ST022

20

65324

20

ST023

9

60540

2

61891

7

D2813 Manufactured No

110 Each

27.0000

2

2



Washer



SB 11/04/13

Location

Loc Qty

Loc Code

ST025

27

61051

27

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3395-1 Manufactured No 110 Each 28.0000 4 4



Bushing



SB 11/04/13

Location Loc Qty Loc Code

ST052 28
60861 28

D3562-042 Manufactured No 110 Each 1.0000 1 1



Step Assembly, RH



4
11/4/13

Location Loc Qty Loc Code

FG110 1
54964 1

MS21043-3 Purchased No 110 Each 1,620.000 4 4



Nut



SB 11/04/13

Location Loc Qty Loc Code

FG 76
103691 76
ST301 1544
112314 1544

MS24665-302 Purchased No 110 Each 25.0000 2 2



Cotter Pin



SB 11/04/13

Location Loc Qty Loc Code

ST309 25
113644 25

2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 65839

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Parent Item Name: Heli Access Step RH Folding

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

MS24693-C280

Purchased

No

110

Each

41.0000

2

2



Screw



SB 11/04/13

Location

Loc Qty

Loc Code

ST310

30

115594

30

ST318

11

111279

11

2

NAS1515H3

Purchased

No

110

Each

158.0000

6

6



Washer



SB 11/04/13

Location

Loc Qty

Loc Code

ST277

158

115675

6

115935

52

116373

100

5

NAS1515H5L

Purchased

No

110

Each

120.0000

4

4



WASHER



SB 11/04/13

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

80

111359

80

4

NAS1515H8

Purchased

No

110

Each

306.0000

4

4



Washer



SB 11/04/13

Location

Loc Qty

Loc Code

ST278

306

111275

106

111411

200

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli Access Step RH Folding

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

AN44C7A
Eyebolt
X1

Purchased

No

130

Each

84.0000

1

1

Location

Loc Qty

Loc Code

ST362

84

109013

44

111308

40

Purchased

No

130

Each

112.0000

1

1

Location

Loc Qty

Loc Code

ST356

112

106302

5

111295

27

112243

50

114523

30

Purchased

No

130

Each

109.0000

2

2

Location

Loc Qty

Loc Code

ST358

109

115835

9

115936

100

AN4C10A
Bolt
X1

AN4C15A
Bolt
X1

11/4/13

11/4/13

11/5/57

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Heli Access Step RH Folding

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

130

Each

431.0000

1

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

327

113121

1

115016

76

116003

200

116400

50

ST358

100

116704

100

AN5C15A

Purchased

No

130

Each

54.0000

2

Bolt

Location

Loc Qty

Loc Code

ST339

54

111819

54

D2806-1

Manufactured

No

130

Each

7.0000

2

Bushing

Location

Loc Qty

Loc Code

ST025

7

46609

7

D2806-3

Manufactured

No

130

Each

7.0000

2

Bushing

Location

Loc Qty

Loc Code

ST025

7

46737

7

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Parent Item Name: Heli Access Step RH Folding

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2810-5

Manufactured No

130 Each

8.0000

1

Strut

Location

Loc Qty

Loc Code

ST265

8

52034

2

64081

6

D3396-1

Manufactured No

130 Each

40.0000

2

Spacer

Location

Loc Qty

Loc Code

ST055

40

46748

40

MS21043-4

Purchased No

130 Each

1,181.000

4

Nut

Location

Loc Qty

Loc Code

ST301

1181

114523

5

114784

2

115936

278

116188

596

116549

300

MS21043-5

Purchased No

130 Each

588.0000

3

Nut

Location

Loc Qty

Loc Code

ST300

100

116548

100

ST301

488

112314

488

Wednesday, January 26, 2011 11:33:37 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H4

Purchased

No

130

Each

103.0000

7



Washer



7
1/14/13

Location

Loc Qty

Loc Code

ST277

103

111525

53

116169

50

7

NAS1515H5

Purchased

No

130

Each

182.0000

7



Washer



7
1/14/13

Location

Loc Qty

Loc Code

FG

44

103286

17

103691

27

ST277

138

109430

138

7

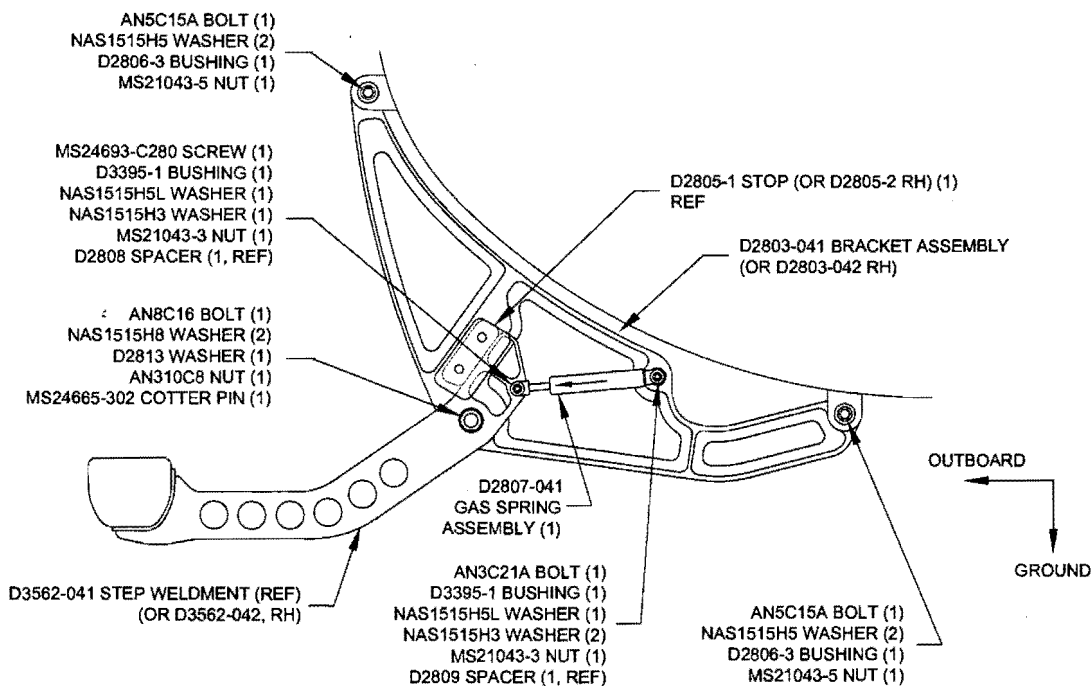
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

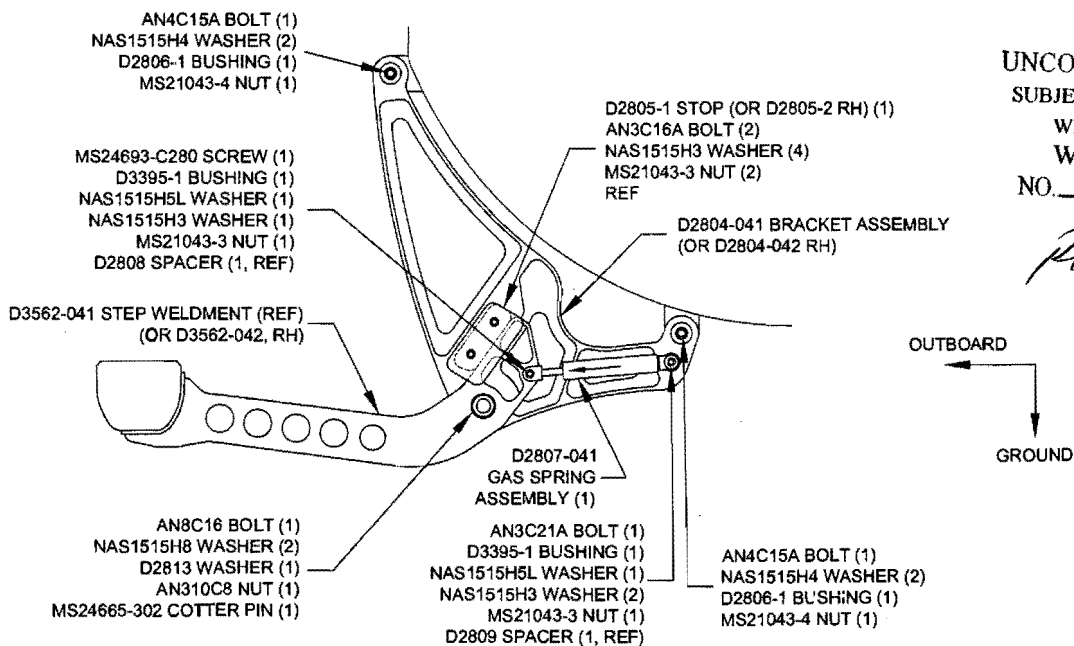
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D412-630-033/-034 Heli-Access-Step™ Installation

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65839

211101-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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